

MOLDING METHOD FOR NON-PAINTING MOLDED ARTICLE OF  
AUTOMOTIVE OUTER PANEL AND MOLDED ARTICLE THEREOF

Abstract

To provide a molding method for non-painting molded article of automotive outer panel with high quality appearance and molded article thereof. The molding method for non-painting molded article of automotive outer panel (high quality appearance) is characterized by carrying out extrusion in metallic mold (wherein,  $T_b > T_c$ ), where the tool temperature ( $T_b$ ) was adjusted  $0^{\circ}\text{C}$  to  $100^{\circ}\text{C}$  higher than heat deformation temperature of injection thermoplastic resin, while heating. After cooling, the tool temperature ( $T_c$ ) was lower down by  $0^{\circ}\text{C}$  to  $100^{\circ}\text{C}$  than heat deformation temperature of injection thermoplastic resin while extraction, during the injection molding of molten composition containing thermoplastic resin composition.

Furthermore, in the invention, the extrusion is carried out in the metallic mold (wherein,  $T_b > T_c$ ), and after the completion of extrusion of resin composition containing molten composition inside the mold, the mold was maintained at high pressure while carrying out extrusion. During the compression flow of extruded molten composition, the tool temperature ( $T_b$ ) was adjusted  $0^{\circ}\text{C}$  to  $100^{\circ}\text{C}$  higher than heat deformation temperature of injection thermoplastic resin, while heating. After cooling, the tool temperature ( $T_c$ ) was lower down by  $0^{\circ}\text{C}$  to  $100^{\circ}\text{C}$  than heat deformation temperature of injection thermoplastic resin while extraction.